Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: AFT BLADE FOLD ASSEMBLY
Job Number	: 45646		
Estimate Number	: 13532		
P.O. Number	:	**Part Number**	: PB674300103
This Issue	: 09/02/2009 **S.O. No.** :	**Drawing Number**	: B6743001 P.1,3,4,15
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SMALL /MED FAB	**Drawing Revision**	: B1
Previous Run	: 45645	**Material**	:
Written By	:	**Due Date**	: 01/04/2009 **Qty:** 1 **Um:** Each
Checked & Approved By	: MF 09-03-03		
Comment	: Est Rev:A 08-07-30 new issue DD verified by:ec		
	Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PB674300109	Aft Blade Fold Assembly Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Aft Blade Fold Assembly Weldment
batch: 45047 MF 09-03-11

2.0	PB674300113	Aft Adjustable Blade Support Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Aft Adjustable Blade Support Assembly
batch: 45042 MF 09-03-11

3.0	PB674300117	Aft Adjustable Blade Support Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Aft Adjustable Blade Support Assembly
batch: 45040 MF 09-03-11

4.0	PB674300121	PB67-43001-21

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
PB67-43001-21
batch: B45038 MF 09-03-11

5.0	PB674300123	PB67-43001-23

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
PB67-43001-23
batch: B 45035 MF 09-03-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT BLADE FOLD ASSEMBLY

Job Number: 45646 **Part Number:** PB674300103

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	PB674300137	PB67-43001-37

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
PB67-43001-37
batch: 45029 CPC 09.03.12

7.0	PB674300157	Stabilizer Arm

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Stabilizer Arm
batch: 45025 CPC 09.03.12

8.0	PB674300159	PB67-43001-59

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
PB67-43001-59
batch: 45024 CPC 09.03.12

9.0	PB674300163	Handle Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Handle Assembly
batch: 45023 CMF 09-03-11

10.0	PB6743001135	Male Eye

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Male Eye
batch: 23995A CMF 09-03-11

11.0	PB6743001155	Pin

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pin
batch: B43093 CMF 09-03-11

12.0	PB6743001261	Lever Arm

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Lever Arm
batch: 43093 CMF 09-03-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT BLADE FOLD ASSEMBLY

Job Number: 45646 **Part Number:** PB674300103

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	PB6743001265	Bushing

04.03.18

Comment: Qty.: ~~5~~ 4.0000 Each(s)/Unit Total : ~~5~~ 4.0000 Each(s)
Bushing batch: ~~47375~~ 44977 lpl 09.03.12

14.0	PB6743001299	Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing batch: 40062 lpl 09.03.12

15.0	PB6743001305	Bearing

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bearing batch: 41886 lpl 09.03.12

16.0	D3451045	Handle and Lock-Down Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Handle and Lock-Down Assembly batch: 45309 lpl 09.03.12

17.0	D3451043	Handle and Lock-Down Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Handle and Lock-Down Assembly batch: 45308 lpl 09.03.12

18.0	D34401	Tube Guide (Supersedes B67-43001-25/-307

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Tube Guide batch: 41347 lpl 09.03.12

19.0	D34403	Clamp (Supersedes B67-43001-309)

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Clamp batch: 41277 lpl 09.03.12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT BLADE FOLD ASSEMBLY

Job Number: 45646 **Part Number:** PB674300103

Job Number:

Seq. #:	Machine Or Operation:	Description :
20.0	D34441	Velcro Loop Belt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Velcro Loop Belt
batch: 39965 lpc 09.03.12

21.0	D34491	Pad

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pad
batch: 45287 lpc 09.03.12

22.0	D34479	Swing Arm

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Swing Arm
batch: 41352 lpc 09.03.12

23.0	086004	Inventory

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Inventory
batch: M109350 lpc 09.03.12

24.0	MS27039107	Screw

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Screw
batch: M18057 lpc 09.03.12

25.0	MS27039123	SCREW

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SCREW
batch: M18057 lpc 09.03.12

26.0	MS21042L4	Nut

Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Nut
batch: M109282 lpc 09.03.12

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT BLADE FOLD ASSEMBLY

Job Number: 45646 **Part Number:** PB674300103

Job Number:

Seq. #:	Machine Or Operation:	Description :
27.0	MS21042L6	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
batch: m108163 lpl 09.03.12

28.0	MS518596	WASHER

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER
batch: m108986 lpl 09.03.12

29.0	MS518598	WASHER

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER
batch: m108986 lpl 09.03.12

30.0	NAS43DD368	SPACER

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SPACER
batch: m109060 lpl 09.03.12

31.0	NAS1149F0316P	WASHER

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WASHER
batch: m111117 lpl 09.03.12

32.0	NAS1149F0432P	Washer

Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Washer
batch: m18057 lpl 09.03.12

33.0	NAS1149F0632P	WASHER

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER
batch: 18057 lpl 09.03.12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT BLADE FOLD ASSEMBLY

Job Number: 45646 **Part Number:** PB674300103

Job Number:

Seq. #:	Machine Or Operation:	Description :
34.0	NAS1149F0832P	WASHER

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
WASHER
batch: 180547 CPL 09.03.12

35.0	AN960JD6	Washer

Comment: Qty.: 5 1.0000 Each(s)/Unit Total : 5 1.0000 Each(s) 04.03.18
Washer
batch: M6085 CPL 09.03.17

36.0	AN410A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M107178 CPL 09.03.12

37.0	AN413A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bolt
batch: M110865 CPL 09.03.12

38.0	AN41~~6~~A 154	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
batch: ~~M110399~~
or AN415A (see engineering) batch: M110399 04.03.18 CPL 09.03.12

39.0	AN611A	BOLT

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
BOLT
batch: M105558 CPL 09.03.12

40.0	AN620A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: ~~M11119~~
or AN6~~0~~16A (see engineering) batch: M11119 04.03.18 CPL 09.03.12

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT BLADE FOLD ASSEMBLY

Job Number: 45646 **Part Number:** PB674300103

Job Number:

Seq. #:	Machine Or Operation:	Description :
41.0	AN813A	BOLT

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
BOLT
batch: m108980 09-03-12

42.0	BSP43	RIVET

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
RIVET
batch: m109119 09.03.12

43.0	CR3213405	cherry rivet

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
cherry rivet
batch: m104214 09.03.12

44.0	MS17984C413	PIN, QUICK RELEASE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
PIN, QUICK RELEASE
batch: _____
or MS17984C410 (see engineering) batch: m109739 09.03.10 09.03.12

45.0	MS17984C418	PIN, QUICK RELEASE

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
PIN, QUICK RELEASE
batch: m108986 x3 09.03.12

46.0	30345T21	LANYARD

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
LANYARD
batch: ~~176250 x1~~ m102812 09.03.12

47.0	30345T24	LANYARDS

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
LANYARDS
batch: m108973 09.03.12

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 10/03/2009 1:15:17 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: AFT BLADE FOLD ASSEMBLY
Job Number	: 45646		
Estimate Number	: 13532		
P.O. Number	:	**Part Number**	: PB674300103
This Issue	: 10/03/2009 **S.O. No.** :	**Drawing Number**	: B6743001 P.1,3,4,15
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: 09/02/2009 **Type** : SMALL /MED FAB	**Drawing Revision**	: B1
Previous Run	: 45645	**Material**	:
Written By	:	**Due Date**	: 01/04/2009 **Qty:** 1 **Um:** Each
Checked & Approved By	: MF 09-03-10		
Comment	: Est Rev:A 08-07-30 new issue DD verified by:ec		
	Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
50.0	MS24694S102	Screw
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Screw M14604	GC 09.03.12
51.0	MS518597	Washer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Washer M106421	GC 09.03.12
52.0	AN526A	BOLT
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	BOLT M18057	GC 09.03.12
53.0	NAS1149F0532P	WASHER
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	WASHER M18057	GC 09.03.12
54.0	MS21042L5	Nut
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
	Nut M110382	GC 09.03.12

Job Completion

Date: Monday, 09/02/2009 4:27:59 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT BLADE FOLD ASSEMBLY

Job Number: 45646 **Part Number:** PB674300103

Job Number:

Seq. #:	Machine Or Operation:	Description :
48.0	240107	SPRING SLOTTED PIN

Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)
SPRING SLOTTED PIN
batch: 111088 x11

49.0	3408A98	DETENT BALL SPRING PLUNG

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DETENT BALL SPRING PLUNG
batch: M111698

50.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.
242 THREADLOCK batch:_____

51.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

52.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____

53.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 12:48:40 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: AFT BLADE FOLD ASSEMBLY
Job Number	: 45646		
Estimate Number	: 13532		
P.O. Number	:	**Part Number**	: PB674300103
This Issue	: 11/03/2009 **S.O. No.** :	**Drawing Number**	: B6743001 P.1,3,4,15
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: 09/02/2009 **Type** : SMALL /MED FAB	**Drawing Revision**	: B1
Previous Run	: 45645	**Material**	:
Written By	:	**Due Date**	: 01/04/2009 **Qty:** 1 **Um:** Each
Checked & Approved By	: MF 09-03-11		
Comment	: Est Rev:A 08-07-30 new issue DD verified by:ec		
	Est Rev:B 08-12-04 up date part list DD Verified by:ec		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
55.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.
242 THREADLOCK batch: M109687 GC 09-03-12

Job Completion